

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024230**Date Inspected:** 28-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	OBG Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

In response to ZPMC NDT Inspection Notification Sheet #09290 for magnetic particle testing (MT) inspection of the following:

This QA Inspector performed random visual testing (VT) and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members were identified as follows:

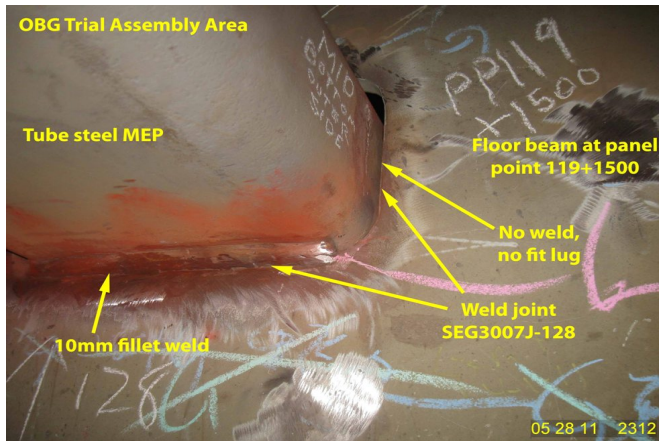
OBG Segment 13AE, SEG3007J. The weld designations reviewed was: 081, 082, 083, 084, 085, 086, 087, 095, 100, 101, 171, 172, 173, 174, 177, 178, 179, 180, 109, 110, 111, 112, 113, 114, 115, 123, 183, 184, 185, 186, 188, 189, 190, 191, 137, 138, 139, 140, 141, 142, 143, 151, 152, 153, 154, 155, 156, 157, 194, 195, 196, 197, 200, 201, 202, 203. No apparent indications were observed.

OBG Segment 13AE, SEG3007J. The weld designations reviewed were: 128, 129. No apparent indications were observed in the weldment that was present. However, the weld map designated welds 128 and 129 to be 'weld all around' or have a fit lug installed. The welds observed were only partial of 'weld all around' and no fit lug was present. See photos below. This QA Inspector generated a Caltrans Incident Report concerning this issue.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer
